

Date: Thursday, 4/12/2007 8:46:22 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 31734		
Estimate Number	: 11480		
P.O. Number	:	Part Number	: D31452
This Issue	: 4/12/2007 S.O. No. : 001	Drawing Number	: D3145 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 26708	Material	:
Written By	:	Due Date	: 5/10/2007 Qty: 6 Um: Each
Checked & Approved By	: <u>[Signature]</u>		
Comment	: Est. A 03.02.28 New issue KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B2000X02000	6061-T6 Bar 2.0" x 2.0"
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Comment: Qty.: 0.4025 f(s)/Unit Total : 2.4148 f(s)
 6061-T6 Bar 2.0" x 2.0"
 Material: 6061-T6/T651 (QQ-A-200/8 or QQ-A-225/8)
 M6061T6B2.000x2.000
 Batch: M16724

JL 08/06/25

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks: (2.00" x 2.00") x 4.500" (+0.030/-0.00) Long Bar

JL 08/06/25

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine per Folio FA318 and Dwg D3145
 Deburr and Tumble

PTO
 DR/SS 08/07/09

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SS 08/07/09

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SS 08/07/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:46:22 AM
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Drawing Name: BRACKET

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Part Number: D31452

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FX 08/07/14

1331734

1031452

14/07/2008

12.02

S.038

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

90 08-07-14

#1

325.5

#2

#3

#4

30

AIN

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ML 08/07/14

(6X)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5769

AS 08/07/15

(6)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/16

Job Completion



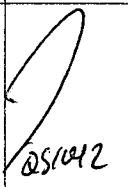
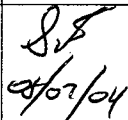

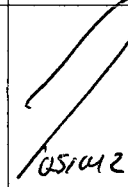
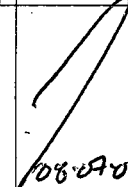
mf 08-07-16

(PTO)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3145-2 PAR #: N/A Fault Category: Prod / Machine Parts NCR: ☒ Yes No DQA: D Date: 08/07/16
D412-694 QA: N/C Closed: D Date: 08/07/16

NCR: 31734		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/07/04	3.0	.195 ^{dimension} for 2 nd operation was off by .020" in the prog offset offset. operator or program error	 Q51042	- h-co offset. - Scraps: destroy & replace Qty 1: <u>M16724</u>	 08/07/04	 080709	 Q51042	 080709
		(don't fist on the jig) R.C. operator error on the set-up						

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	31734
Description: Bracket		Part Number:	D3145-2
Inspection Dwg: D3145 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.188	+/-0.010	.188	✓			
0.125	+/-0.010	.128	✓			
1.636	+/-0.010	1.634	✓			
0.125	+/-0.010	.120	✓			
0.766	+/-0.010	.765	✓			
0.250	+/-0.010	.256	✓			
1.370	+/-0.010	1.376	✓			
0.760	+/-0.010	.760	✓			
4.303	+/-0.010	4.312	✓			
0.125	+/-0.010	.126	✓			
0.219	+/-0.010	.228	✓			
R0.125	+/-0.010	.125	✓			
1.960	+/-0.010	1.962	✓			
1.250	+/-0.010	1.252	✓			
0.180	+/-0.010	.184	✓			
R0.250	+/-0.010	.250	✓			
0.240	+/-0.010	.245	✓			
0.108	+/-0.010	.110	✓			
Ø0.221 x 0.351	+/-0.010	.222 x .352	✓			

Measured by:	S.F.
Date:	08/07/04

Audited by:	Qm
Date:	08/07/05

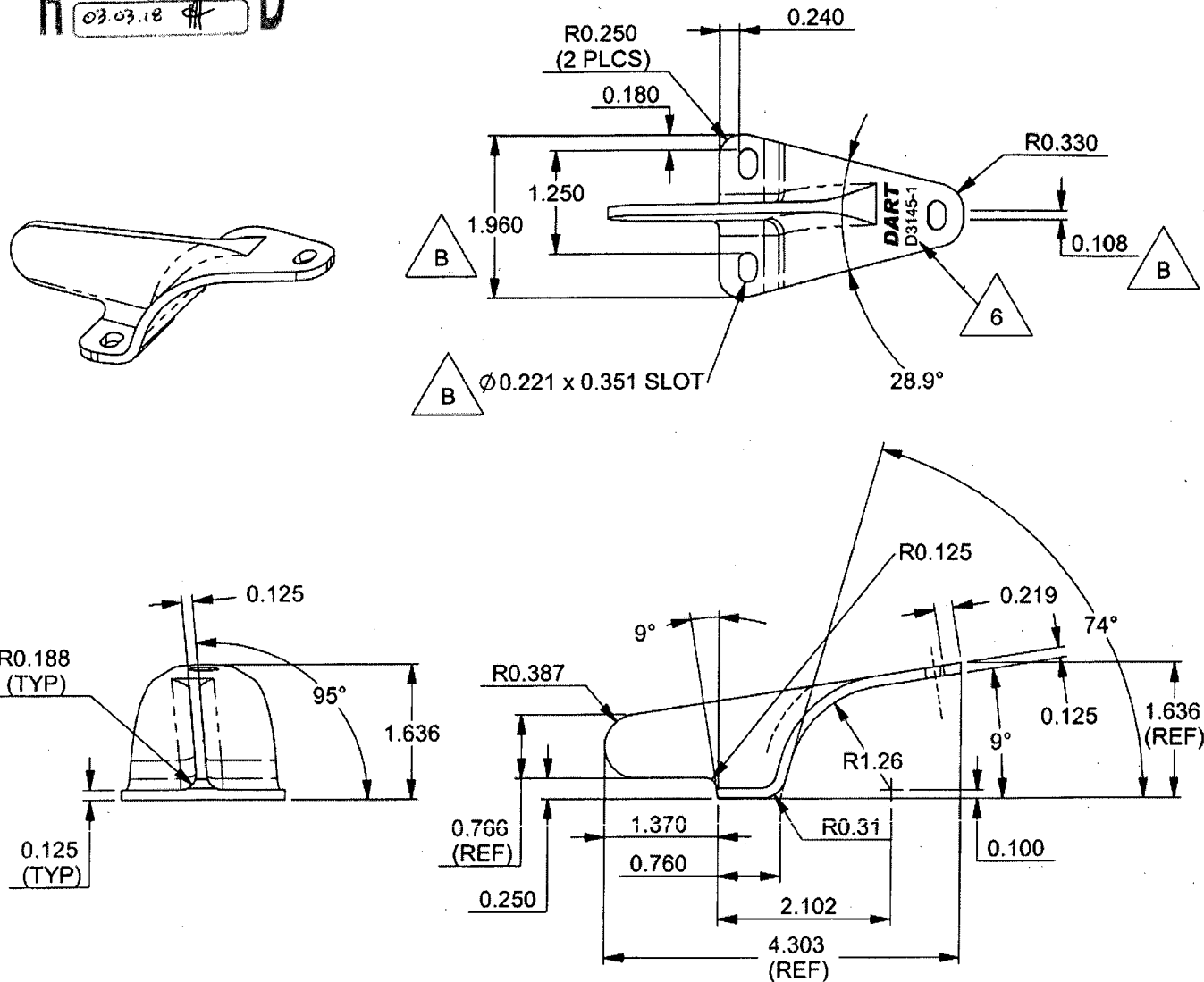
Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.05.10	New Issue	KJ/JLM	



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3145	REV. B SHEET 1 OF 1
DATE 03.02.06		TITLE BRACKET	SCALE 1:2
A	02.04.24	NEW ISSUE	
B	03.02.06	ADD SLOTS; WIDEN TABS; 1.960 WAS 2.000	

RELEASED
03.03.18



D3145-1 BRACKET SHOWN. REPLACES PREMIER P/N B30-23000-25
(D3145-2 BRACKET OPPOSITE. REPLACES PREMIER P/N B30-23000-26)

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N AND LOGO AS SHOWN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31734

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